



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

00361

20NR-04

Job Sheet 177410



Part No: 20NR-04

Job Qty: 2 ea

Part Name: Solenoid



Part Weight: 0 lbs

Status: Scheduled

At Planning

Priority: Medium

Job Created: 5/10/18

Job Tracking No:

Due Date: 5/23/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG 20NR-04 Rev 6 IPP Rev A 18.02.02 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	5/23/18	5/23/18	0.00	0.00	Start Up Small Fab-4		
100	Small Fab	2 pcs	5/23/18	5/23/18	0.08	0.20	Small Fab-9		AP
110	QC	2 pcs	5/23/18	5/23/18	0.00	0.00	QC5		10-05-11
130	Packaging	2 pcs	5/23/18	5/23/18	0.00	0.00	Packaging3-2		DAS
140	QC21-FG	2 Ea	5/23/18	5/23/18	0.00	0.00	QC21		21 MAY 11 2018

Part Op 100 - 1-Assemble as per DWG sheet 1. 2-Center 20NR-03 in shaft of solenoid as per note 1. ***Note 32446 22-16 crimp
Descriptions: connectors supplied loose as per note 2***
130 - Bag and tag

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
20NR-04-1	Solenoid	2 Ea (1 ea)	90-Start up Operation	5070434
20NR-04-3	Spacer	2 Ea (1 ea)	90-Start up Operation	5045989
32446	Crimp Terminal	4 Ea (2 ea)	90-Start up Operation	5047675
92383A695	Slotted Spring Pin	2 Ea (1 ea)	90-Start up Operation	5040831

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	20NR-04-1	2	0	0
			5	0
			100	0
			155	0



Container No: S070457



Part: 20NR-04

Job No: 177410

Serial No/Batch: S070457

Revision: 6

Inspector:

\$

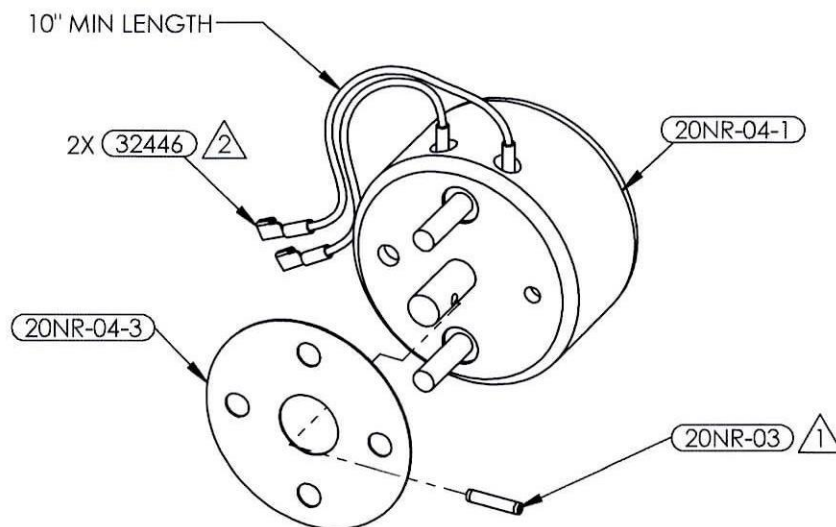
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Date: 05/11/18

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
5		AS DRAWN BY CANAM.	7/18/2013	CFS	
6	14-0206	CH'D TITLEBLOCK WAS RED BARN IS DART. 20NR-04-1 ADDED ENGRAVE BATCH # NOTE. ADDED 20NR-04-3 SPACER, 2X 32446 CONNECTORS. ADDED MIN LENGTH NOTE.	11/3/2014	DPD	JAG



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 127410 *ms*
180511

NOTE:

- ① CENTER 20NR-03 IN SHAFT OF SOLENOID.
② CONNECTORS SUPPLIED LOOSE.

USED ON
20NR
8NR

DART AEROSPACE	
TITLE SOLENOID ASSEMBLY	
DWG NO. 20NR-04	REV 6
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1	DRAWN BY: CANAM APPROVED: <i>D Weil</i> HEAT TREAT FINISH SPEC USED ON MODEL
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:2	DATE 12/1/1998 SHEET 1 OF 3

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
		B/O	20NR-03	1	SOLENOID PIN	S.S.	Ø1/8 X 5/8 MCMASTER-CARR #92383A695	1
		B/O	20NR-04-1	1	SOLENOID		H-1127-020 (MODIFIED)	2
			20NR-04-3	1	SPACER	PETG	Ø2-5/8 X .020	3
		B/O	32446	2	22-16 AWG KNIFE CONNECTOR		ALLIED ELECTRONICS 32446	1